



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW5305G81851-3G-7
Job Sheet 184935



Part No: RBW5305G81851-3G-7

Job Qty: 2 ea

Part Name: Left Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW5305G81851-3G REV 1D IPP REV A 18.05.28 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Large Fab-1		EZ
110	Large Fab	2 pcs	10/26/18	10/26/18	0.00	4.00	Large Fab 2		EZ
115	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC9		EZ
120	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC5		EZ
122	Small Fab	2 pcs	10/26/18	10/26/18	0.00	0.33	Small Fab-3		AD
124	Mill Conv	2 pcs	10/26/18	10/26/18	0.00	0.33	Mill Conv 2		FRD 18-12-27
126	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC2 Machining-3		FRD 18-12-27
128	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC8 Machining-3		M. 18-17-27
138	Powdercoat	2 pcs	10/26/18	10/26/18	0.00	0.20	Powdercoat6		BEB 18-12-28
140	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC3		DEC 2 8 2018 68
180	Packaging	2 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3		MLC 9-8-18 GA
190	QC21-FG	2 Ea	10/26/18	10/26/18	0.00	0.00	QC21		DEC 2 8 2018 70 9-8-18

Part Op 110 - Weld as per DWG.

Descriptions: 122 - 1- Load test each weldment at 750-800 lbs.

124 - 1- Skim bottom after welding as per DWG

M129223 138 - START TIME: 10:30 OVEN TEMPERATURE: 320° FINISH TIME: 11:00

Job BOM

007042

Part / Item	Component Name	Quantity	Operation	Container
RBW5305G81851-3G-5	Plate	2 Ea (1 ea)	90-Start up Operation	131971 5770570
RBW5305G81851-3G-9	Left Tab	2 Ea (1 ea)	90-Start up Operation	5119205

Job Allocations

Operation	Required	Inventory	Allocated
90-Start up Operation	2	0	0
	2	8	0



Container No: S137362



Part: RBW5305G81851-3G-7

Job No: 184935

Serial No/Batch: S137362

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 10/18/18 11:32 AM Dart.lajeunesse.marie

Date: 12/12/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

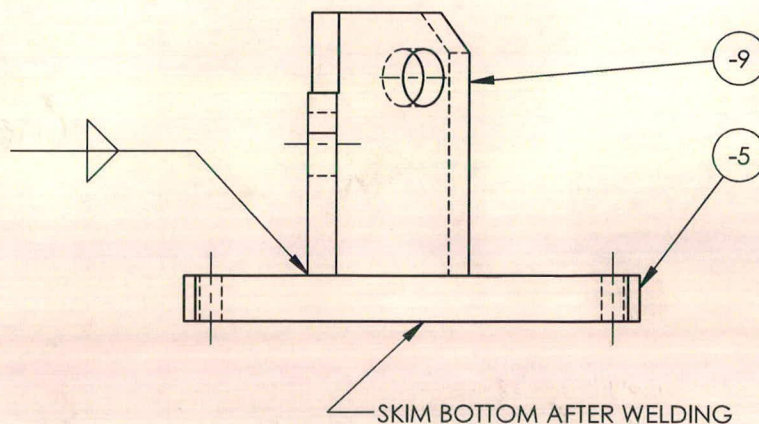
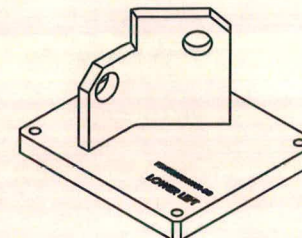
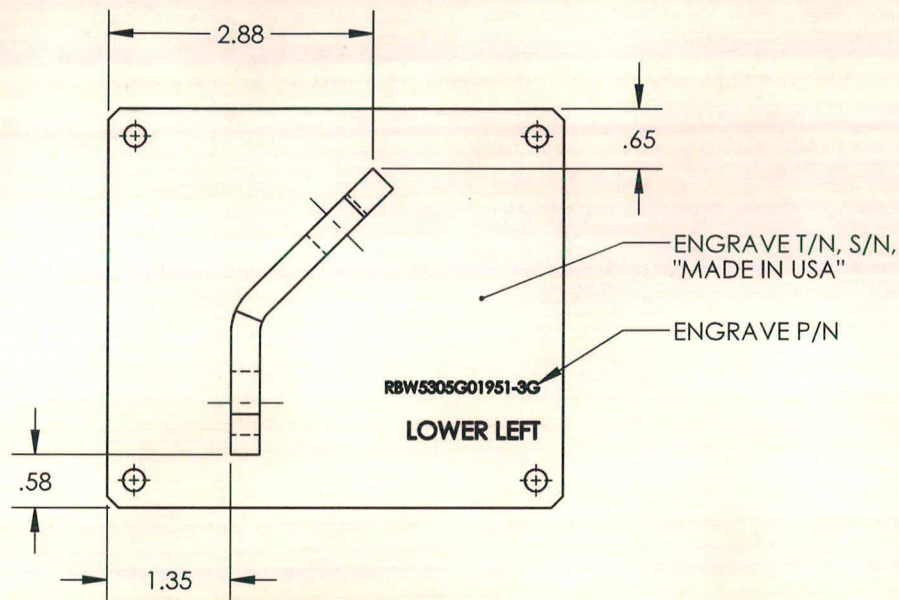
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

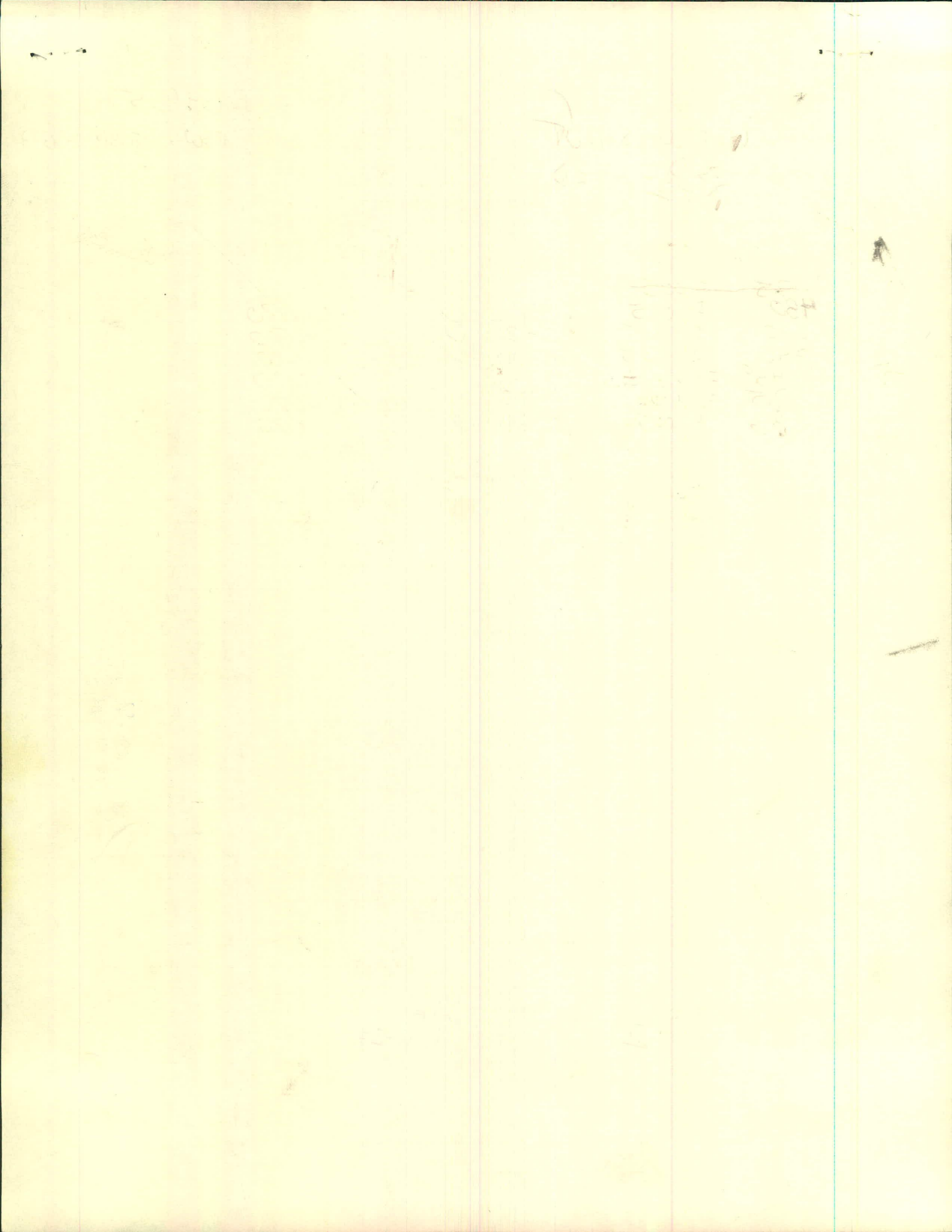
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1D	-7 CH'D FINISH WAS POWDER COAT FORREST #T-5920 S9 YELLOW RIBBON IS POWDER COAT YELLOW FED#13538.	7/2/2014	DPD
			RJC



-7
LEFT WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187935 M05
1870-18

DART AEROSPACE	
TITLE T/B LIFT FITTINGS	
DWG NO. RBW5305G81851-3G-7	REV 1D
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: DUERFELDT APPROVED: D Weil HEAT TREAT FINISH: POWDER COAT YELLOW SPEC: FED #13538 USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 7/2/2014
SHEET 5 OF 6	





WLO 184938

Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

RBW5305G81851-36-7

1D

S137362

2018 DEC 21

Proof Load Capacity

800

LBS

Tested By:

ALAIN PATRY

Technician

Approval: _____

Position: _____

QC 5 Small FAB / QA

2



Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

RBW5305G81851-3G-7

1D

5137362

2018 DEC 21

Proof Load Capacity

800

LBS

Tested By:

ALAIN PATRY

Technician

Approval: _____

Position: _____

QC 5 Small FAB / QA

12-10-94

12-10-94

12

12-10-94

12-10-94

12-10-94